

6031 Hex 1"

Work Order ID 68492

Thursday, April 14, 2011 10:14:09 AM



Page 1

Item ID: D2806-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: H Date: 4-14-11

Tooling:

Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2806

Rev A

100

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1- Turn as per Folio FA105 Rev: H & Dwg D2806 Rev: H ☐ 2-Deburr
per dwg D2806

20 11-6-7

20

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

20 11-6-7

20

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

20 11/6/7

20

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
|------|------|----------------------------------|----------------------|---------------------------------|-----------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action | | Section B | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 68492

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Page 2

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Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

20X ~~✓~~ M-11/06/09

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

20 ~~✓~~ PK 11-6-9

150

Identify as per dwg & Stock Location: 22

0.00



Packaging

Memo

0.00

Packaging

11/6/11 SL 201

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 68492

Thursday, April 14, 2011 10:14:09 AM



Page 3

Item ID: D2806-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bushing

Start Date: 4/14/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13

MF

11-06-10

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Thursday, April 14, 2011 10:14:16 AM

Page 1

Work Order ID: 68492

Parent Item: D2806-1

Parent Item Name: Bushing



Start Date: 4/14/2011

Required Date: 4/21/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: ☐B☐05.03.11☐Part now turned☐ KJ/JLM☐
IPP Rev:C Now on Doosan Lathe JLM Verified By:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M6061T6H1.000

Purchased

No

100

f

16.4500

0.0916

1.928421



20 11.6.7

6061-T6 HexBar 1.00

Location

Loc Qty

Loc Code

MAT012

16.45

109478

4.45

116623

12

1.516

| W/O: | | WORK ORDER CHANGES | | | | | | | |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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NOTE: Date & initial all entries

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|-----------------------|--------|----------------------|
| DART AEROSPACE LTD | | Work Order: 68492 |
| Description: Bushing | | Part Number: D2806-1 |
| Inspection Dwg: D2806 | Rev: A | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|-----------|
| 1.000 | +/-0.010 | .999 | / | | Re .02 | |
| 1.155 | +/-0.010 | 1.140 | / | | | STK MAT'L |
| 0.250 | +/-0.010 | .253 | / | | | |
| 0.063 x 45° | +/-0.010 | .066 | / | | | |
| 0.080 x 45° | +/-0.010 | .075 | / | | | |
| 0.495 | +0.000/-0.005 | .491 | / | | | |
| 0.750 | +0.000/-0.005 | .748 | / | | | |
| Ø0.257 | +0.005/-0.000 | .259 | / | | | |
| 0.094 | +/-0.010 | .091 | / | | | |
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|-----------------|-------------------------|---------------------|-----|
| Measured by: RE | Audited by: [Signature] | Prototype Approval: | N/A |
| Date: 11.6.7 | Date: 11/6/7 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------------------|------------|-------------|
| A | 04.02.25 | New Issue | KJ/RF | |
| B | 08.01.16 | 0.094 dimension added | KJ/EC/DD | [Signature] |

| W/O: | | WORK ORDER CHANGES | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

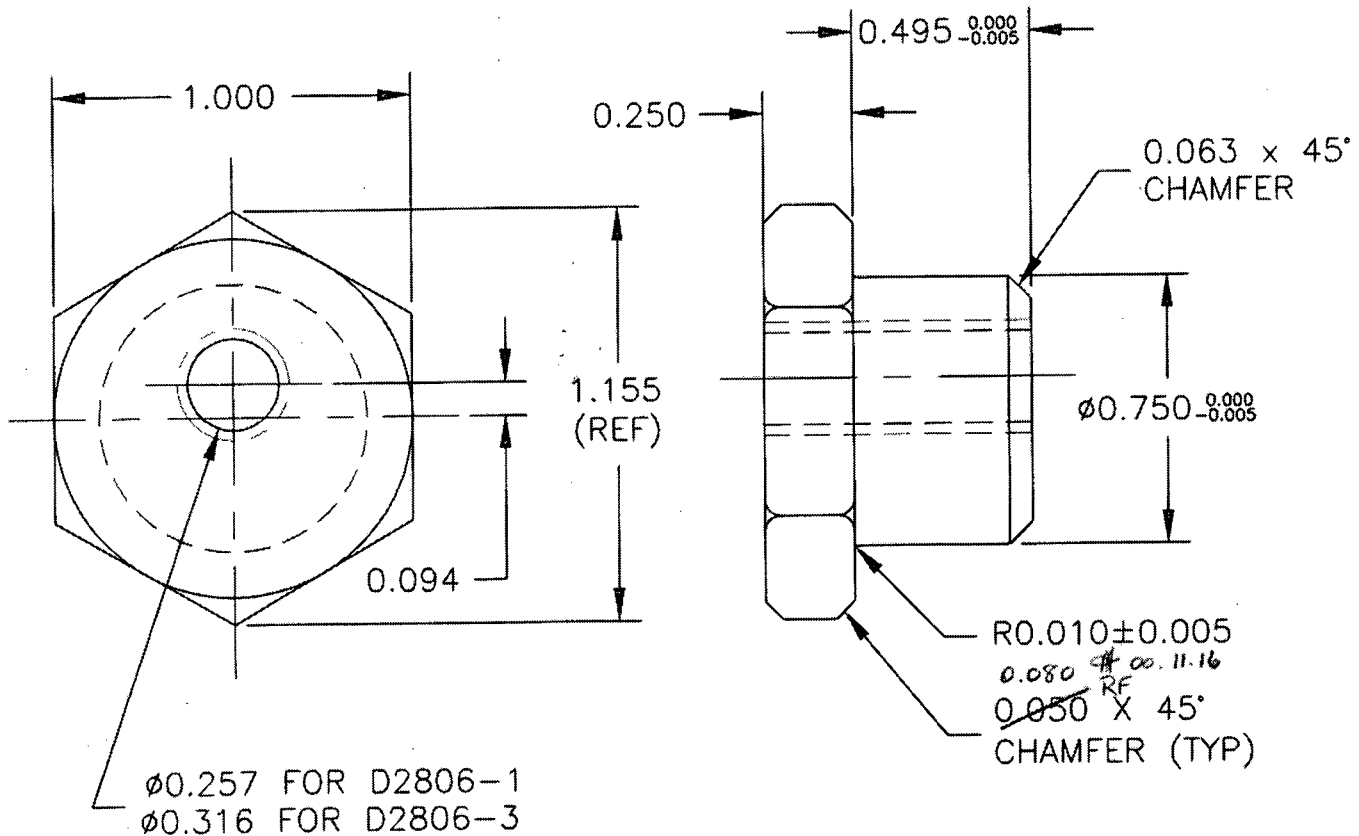
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NOTE: Date & initial all entries



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|----------------------------|-----------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2806 | REV. A SHEET 1 OF 1 |
| DATE 00.11.08 | | TITLE BUSHING | SCALE 2:1 |
| A | 00.11.08 | NEW ISSUE | |

RELEASED
00.11.13 *[Signature]*



D2806-1 (DRILL $\phi 0.257$ HOLE)
D2806-3 (DRILL $\phi 0.316$ HOLE)

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68492

PL 11-01-14

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